

Work Order ID 113337

February-12-14 11:20:30 AM

D4276-1

D413337

\*113337\*

Page 1

Item ID: D4276-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Beam

Start Date: 2/12/14 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 2/12/14 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 11-02-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4276    | A            |

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 36.630"  
Batch: 1128980

OK 14/05/12

4 0

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB007  
DWG REV: A  
FOLIO REV: AA

OK 14/05/19

4 0

2- deburr rough edges

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|  |  |  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>   | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>   | Rec/Store/Packaging <input type="checkbox"/>   | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>   | Supplier <input type="checkbox"/>  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design        |      |      |     |   |                   |                    |             |              |              |
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Handling/Pre  |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup  |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Transport     |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |
|--|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge   |  |   |
| <input type="checkbox"/> Pressure/Forced<br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other   |  |   |

**Work Order ID 113337**

February-12-14 11:20:30 AM

**\*113337\***

Page 2

Item ID: D4276-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Aft Beam  
Start Date: 2/12/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 2/12/14 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool #             | Plan<br>Code | Accept<br>Qty | Reject<br>Qty    | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|--------------------|--------------|---------------|------------------|------------------|----------------|
| 120<br><b>*120*</b><br>QC<br>Quality Control        | QC2- Inspect parts off machine FAI/FAIB<br><br>Memo | 0.00<br><br>0.00     |         | <i>am 14/05/20</i> |              | <u>4</u>      | <u>0</u>         |                  |                |
| 130<br><b>*130*</b><br>QC<br>Quality Control        | QC8- Inspect parts - second check<br><br>Memo       | 0.00<br><br>0.00     |         | <i>MH 14/05/21</i> |              | <u>4</u>      | <u>0</u>         |                  |                |
| 140<br><b>*140*</b><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo | 0.00<br><br>0.00     |         |                    |              | <u>4</u>      | <u>76 145-21</u> |                  |                |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|  |  |  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>   | Engineering <input type="checkbox"/> |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>   | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>   | Rec/Store/Packaging <input type="checkbox"/>   | Other <input type="checkbox"/>       |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>   | Supplier <input type="checkbox"/>  |                                      |                                    |                                    |                                      |                                    |                                    |  |                                  |  |                                    |  |                                |                                    |                                    |                                   |  |

| Root Cause    | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design        |      |      |     |   |                   |                    |             |              |              |
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Handling/Pre  |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup  |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Transport     |      |      |     |   |                   |                    |             |              |              |
| Unapproved    |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|  |  |   |
|--|--|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending<br><input type="checkbox"/> Centre Not Concentric<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crimp/Kink/Ripple/Wave<br><input type="checkbox"/> Cuffs<br><input type="checkbox"/> Crushing<br><input type="checkbox"/> Heat Treat<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Marks/Chatter<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>General</b><br><input type="checkbox"/> Bend<br><input type="checkbox"/> BOM/Route<br><input type="checkbox"/> Broken/Damage/Defect<br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Countersink<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Drawing<br><input type="checkbox"/> Drill Holes<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program<br><input type="checkbox"/> Grain<br><input type="checkbox"/> Hardware<br><input type="checkbox"/> Inspection Incomplete/Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Misaligned/off center<br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Misread<br><input type="checkbox"/> Off-set<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Incorrect<br><input type="checkbox"/> Part Lost/Missing<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Power Loss/Surge   |  |   |
| <input type="checkbox"/> Pressure/Forced Set-up<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other   |  |   |

Work Order ID 113337 **DA 13337**

**\*113337\***

February-12-14 11:20:30 AM

Item ID: D4276-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Aft Beam  
Start Date: 2/12/14      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 2/12/14      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                      | Operation<br>Description   | Set Up/<br>Run Hours                                      | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty  | Reject<br>Number | Insp.<br>Stamp        |
|---|--|---|---------|--------|--------------|---------------|----------------|------------------|-----------------------|
| 145<br><b>*145*</b><br>Powdercoat<br>Powder Coating | White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum<br><i>M 128 939.</i><br>Memo<br>MASK AS PER DWG | 0.00<br><i>ST: 10:25.<br/>OVEN: T: 320°<br/>F: 10:55.</i> |         |        |              | <i>4</i>      | <i>14-5-22</i> |                  | <i>DAS 27 14/5/22</i> |
| 150<br><b>*150*</b><br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo   | 0.00<br>0.00  |         |        |              | <i>4</i>      |                |                  |                       |
| 180<br><b>*180*</b><br>Packaging<br>Packaging       | Identify as per dwg & Stock Location: <i>ST/69.</i><br><br>Memo                              | 0.00<br>0.00  |         |        |              | <i>4X</i>     | <i>14-5-22</i> | <i>8P</i>        |                       |

Item ID: D4276-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Aft Beam  
Start Date: 2/12/14      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 2/12/14      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

| Sequence ID/<br>Work Center ID               | Operation<br>Description                                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190<br><b>*190*</b><br>QC<br>Quality Control | QC21- Final Inspection - Work Order Release<br><br>Memo | 0.00<br>0.00         |         |        |              |               |               |                  |                |

*14/5/22*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

| Work Order: _____<br>Part No. _____<br>NCR No. _____ |      |      |                | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Thermoforming <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Crosstube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Composite <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Quality <input type="checkbox"/><br>Other <input type="checkbox"/> |             |   |   |  |  |
|--|------|------|----------------|--|-------------------|--|-------------|---|---|--|--|
| Root Cause   | Date | Step | Qty            | Description of work order update or non-conformance  | Initial Chief Eng | Action Description   | Sign & Date | Verification                                  | QC Inspector                                |  |  |
| Design <input type="checkbox"/>                      |      |      |                |  |                   |  |             |   |   |  |  |
| Doc/Data <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Equip/Tooling <input type="checkbox"/>               |      |      |                |  |                   |  |             |   |   |  |  |
| Handling/Pre <input type="checkbox"/>                |      |      |                |  |                   |  |             |   |   |  |  |
| Material <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Operator <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Offset/Setup <input type="checkbox"/>                |      |      |                |  |                   |  |             |   |   |  |  |
| Process <input type="checkbox"/>                     |      |      |                |  |                   |  |             |   |   |  |  |
| Supplier <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Training <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Transport <input type="checkbox"/>                   |      |      |                |  |                   |  |             |   |   |  |  |
| Unapproved <input type="checkbox"/>                  |      |      |                |  |                   |  |             |   |   |  |  |
| <b>FAULT CATEGORY</b>                                |      |      |                |  |                   |  |             |   |   |  |  |
| <b>Landing Gear</b>                                  |      |      | <b>General</b> |  |                   |  |             |   |   |  |  |
| <input type="checkbox"/> Bending                     |      |      |                | <input type="checkbox"/> Bend  |                   | <input type="checkbox"/> Folio/Program   |             | <input type="checkbox"/> Outside Dimensions   | <input type="checkbox"/> Pressure/Forced    |  |  |
| <input type="checkbox"/> Centre Not Concentric       |      |      |                | <input type="checkbox"/> BOM/Route   |                   | <input type="checkbox"/> Grain   |             | <input type="checkbox"/> Over/Under tolerance | <input type="checkbox"/> Set-up             |  |  |
| <input type="checkbox"/> Cracks                      |      |      |                | <input type="checkbox"/> Broken/Damage/Defect  |                   | <input type="checkbox"/> Hardware  |             | <input type="checkbox"/> Part Incorrect       | <input type="checkbox"/> Temperature/Cure   |  |  |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave      |      |      |                | <input type="checkbox"/> Burrs   |                   | <input type="checkbox"/> Inspection Incomplete/Unqualified   |             | <input type="checkbox"/> Part Lost/Missing    | <input type="checkbox"/> Weld               |  |  |
| <input type="checkbox"/> Cuffs                       |      |      |                | <input type="checkbox"/> Contamination   |                   | <input type="checkbox"/> Instructions Incomplete/Unclear   |             | <input type="checkbox"/> Part Moved           | <input type="checkbox"/> Wrong Stock Pulled |  |  |
| <input type="checkbox"/> Crushing                    |      |      |                | <input type="checkbox"/> Countersink   |                   | <input type="checkbox"/> Misaligned/off center   |             | <input type="checkbox"/> Positioned Wrong     | <input type="checkbox"/> Other              |  |  |
| <input type="checkbox"/> Heat Treat                  |      |      |                | <input type="checkbox"/> Cut Too Short   |                   | <input type="checkbox"/> Mislabeled  |             | <input type="checkbox"/> Power Loss/Surge     |   |  |  |

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_


Work Order update only ☐



| Work Order: _____<br>Part No. _____<br>NCR No. _____ |      |      |                | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |                   | <b>AGAINST DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Thermoforming <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Crosstube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Composite <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Quality <input type="checkbox"/><br>Other <input type="checkbox"/> |             |   |   |  |  |
|--|------|------|----------------|--|-------------------|--|-------------|---|---|--|--|
| Root Cause   | Date | Step | Qty            | Description of work order update or non-conformance  | Initial Chief Eng | Action Description   | Sign & Date | Verification                                  | QC Inspector                                |  |  |
| Design <input type="checkbox"/>                      |      |      |                |  |                   |  |             |   |   |  |  |
| Doc/Data <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Equip/Tooling <input type="checkbox"/>               |      |      |                |  |                   |  |             |   |   |  |  |
| Handling/Pre <input type="checkbox"/>                |      |      |                |  |                   |  |             |   |   |  |  |
| Material <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Operator <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Offset/Setup <input type="checkbox"/>                |      |      |                |  |                   |  |             |   |   |  |  |
| Process <input type="checkbox"/>                     |      |      |                |  |                   |  |             |   |   |  |  |
| Supplier <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Training <input type="checkbox"/>                    |      |      |                |  |                   |  |             |   |   |  |  |
| Transport <input type="checkbox"/>                   |      |      |                |  |                   |  |             |   |   |  |  |
| Unapproved <input type="checkbox"/>                  |      |      |                |  |                   |  |             |   |   |  |  |
| <b>FAULT CATEGORY</b>                                |      |      |                |  |                   |  |             |   |   |  |  |
| <b>Landing Gear</b>                                  |      |      | <b>General</b> |  |                   |  |             |   |   |  |  |
| <input type="checkbox"/> Bending                     |      |      |                | <input type="checkbox"/> Bend  |                   | <input type="checkbox"/> Folio/Program   |             | <input type="checkbox"/> Outside Dimensions   | <input type="checkbox"/> Pressure/Forced    |  |  |
| <input type="checkbox"/> Centre Not Concentric       |      |      |                | <input type="checkbox"/> BOM/Route   |                   | <input type="checkbox"/> Grain   |             | <input type="checkbox"/> Over/Under tolerance | <input type="checkbox"/> Set-up             |  |  |
| <input type="checkbox"/> Cracks                      |      |      |                | <input type="checkbox"/> Broken/Damage/Defect  |                   | <input type="checkbox"/> Hardware  |             | <input type="checkbox"/> Part Incorrect       | <input type="checkbox"/> Temperature/Cure   |  |  |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave      |      |      |                | <input type="checkbox"/> Burrs   |                   | <input type="checkbox"/> Inspection Incomplete/Unqualified   |             | <input type="checkbox"/> Part Lost/Missing    | <input type="checkbox"/> Weld               |  |  |
| <input type="checkbox"/> Cuffs                       |      |      |                | <input type="checkbox"/> Contamination   |                   | <input type="checkbox"/> Instructions Incomplete/Unclear   |             | <input type="checkbox"/> Part Moved           | <input type="checkbox"/> Wrong Stock Pulled |  |  |
| <input type="checkbox"/> Crushing                    |      |      |                | <input type="checkbox"/> Countersink   |                   | <input type="checkbox"/> Misaligned/off center   |             | <input type="checkbox"/> Positioned Wrong     | <input type="checkbox"/> Other              |  |  |
| <input type="checkbox"/> Heat Treat                  |      |      |                | <input type="checkbox"/> Cut Too Short   |                   | <input type="checkbox"/> Mislabeled  |             | <input type="checkbox"/> Power Loss/Surge     |   |  |  |
| <input type="checkbox"/> Inspection Strip in Tube    |      |      |                | <input type="checkbox"/> Drawing   |                   | <input type="checkbox"/> Misread   |             |   |   |  |  |
| <input type="checkbox"/> Marks/Chatter               |      |      |                | <input type="checkbox"/> Drill Holes   |                   | <input type="checkbox"/> Off-set   |             |   |   |  |  |
| <input type="checkbox"/> Turning Sequence            |      |      |                | <input type="checkbox"/> Finish  |                   | <input type="checkbox"/> Out of Calibration  |             |   |   |  |  |
| <input type="checkbox"/> Wave/Twist in Tube          |      |      |                | <input type="checkbox"/> Fit/Function  |                   | <input type="checkbox"/> Out of Sequence   |             |   |   |  |  |

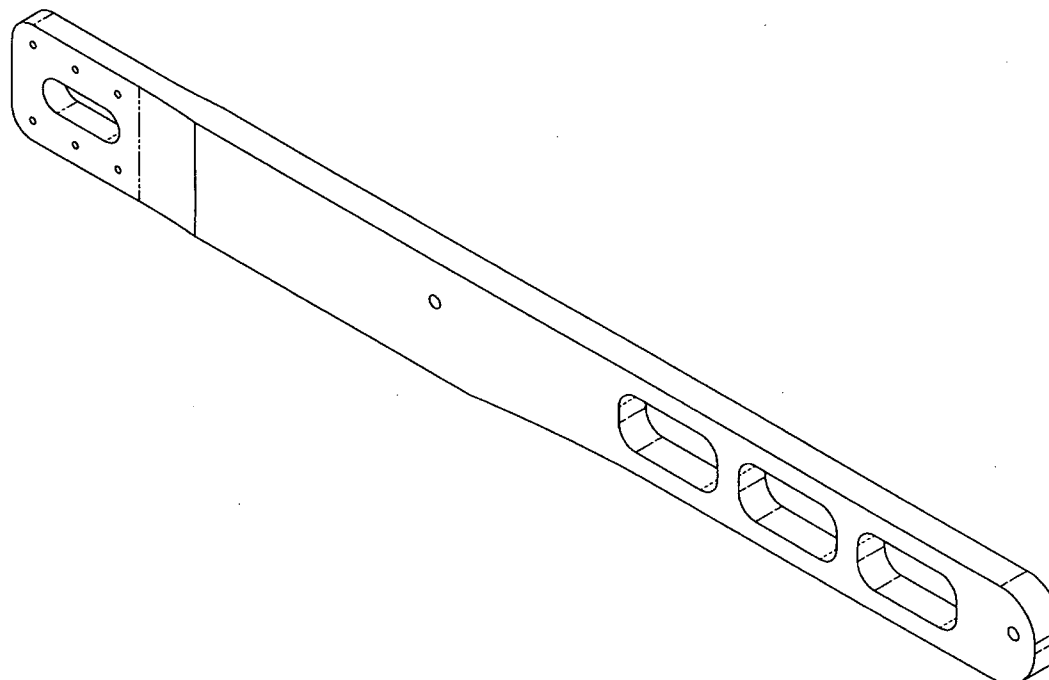
|                              |               |                             |
|------------------------------|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> 113337   |
| <b>Description:</b> Aft Beam |               | <b>Part Number:</b> D4276-1 |
| <b>Inspection Dwg:</b> D4276 | <b>Rev:</b> A | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.75              | +/-0.030      | .750             | —      |        | Vern                 | ML-06    |
| 20.500            | +/-0.010      | 20.500           | —      |        | M+Tape               |          |
| Ø0.381            | +0.000/-0.001 | .380             | ✓      |        | g-pin                |          |
| 14.380            | +/-0.010      | 14.380           | —      |        | M-Tape               |          |
| R0.75             | +/-0.030      | R.750            | —      |        | R-b                  |          |
| 3.50              | +/-0.030      | 3.502            | —      |        | Vern                 | ML-06    |
| 16.38             | +/-0.030      | 16.380           | —      |        | M-Tape               |          |
| 5.00              | +/-0.030      | 5.000            | —      |        | Vern                 | ML-06    |
| 0.75              | +/-0.030      | .750             | —      |        | "                    |          |
| 2.75              | +/-0.030      | 2.750            | —      |        | "                    |          |
| 3.00              | +/-0.030      | 3.003            | —      |        | "                    |          |
| 1.250             | +/-0.010      | 1.250            | —      |        | "                    |          |
| 4.50              | +/-0.030      | 4.500            | —      |        | "                    |          |
| 0.734             | +/-0.010      | .741             | —      |        | "                    |          |
| 0.108             | +/-0.010      | .108             | —      |        | "                    |          |
| 36.38             | +/-0.030      | 36.395           | —      |        | M-Tape               |          |
| 0.95              | +/-0.030      | .956             | —      |        | Vern                 | ML-06    |
| 0.60              | +/-0.030      | .603             | —      |        | "                    |          |
| 2.70              | +/-0.030      | 2.697            | —      |        | "                    |          |
| 1.10              | +/-0.030      | 1.100            | —      |        | "                    |          |
| 1.25              | +/-0.030      | 1.256            | —      |        | "                    |          |
| 0.75              | +/-0.030      | .748             | —      |        | "                    |          |
| 3.000             | +/-0.010      | 3.000            | —      |        | "                    |          |
| 1.500             | +/-0.010      | 1.500            | —      |        | "                    |          |
| Ø0.191            | +0.005/-0.001 | Ø.192            | —      |        | "                    |          |
| 2.300             | +/-0.010      | 2.300            | —      |        | "                    |          |
| 3.50              | +/-0.030      | 3.500            | —      |        | "                    |          |
| R0.60             | +/-0.030      | R.600            | —      |        | R-b                  |          |
| 1.70              | +/-0.030      | 1.698            | —      |        | Vern                 | ML-06    |
| 0.65              | +/-0.030      | .647             | —      |        | "                    |          |

|   |                       |                              |
|---|-----------------------|------------------------------|
| <b>Measured by:</b>  | <b>Audited by:</b> PH | <b>Preliminary Approval:</b> |
| <b>Date:</b> 14/05/20   | <b>Date:</b> 14/05/21 | <b>Date:</b>                 |

|            |             |               |  |   |
|------------|-------------|---------------|--|---|
| <b>Rev</b> | <b>Date</b> | <b>Change</b> | <b>Revised by</b>  | <b>Approved</b>   |
| A          | 11.08.22    | New Issue     | KJ  |  |



**D4276-1 AFT BEAM**

113337 MJS  
14-02-13

RELEASE  
2010-11-30

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

|            |             |  |              |    |          |
|------------|-------------|--|--------------|----|----------|
| A          |             | NEW ISSUE  |              | SC | 10.11.25 |
| REV.       | DESCRIPTION |  |              | BY | DATE     |
| DESIGN     | SC          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA  |              |    |          |
| DRAWN      | JPH         |  |              |    |          |
| CHECKED    | #           | DRAWING NO.  | REV. A       |    |          |
| MFG. APPR. | #           | D4276  | SHEET 1 OF 2 |    |          |
| APPROVED   | #           | TITLE  | SCALE        |    |          |
| DE APPR.   | #           | AFT BEAM   | NTS          |    |          |
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